

76283

Tuesday, November 08, 2011 1:31:36 PM

N900040100

Setup Start *NS1*

Stop ***NS2***

10

10

Reference:

Run Start *NR1*

Date:

SPC (Y/N):

Date:

Stop *NR2*

Draw Nbr	Revision Nbr	
D3908	C	

0.00

*** 100 ***

Memo

CUT BLANK 4.00" LONG

0.00

FL- 11/11/13

10



0.00

110

Mémo

MACHINE AS PER FOLIO FA866 AND DWG

FOLIO REV: AA
DWG REV: C

0.00

A handwritten signature in black ink, appearing to be "J. A. [unclear]". The signature is written diagonally across the page.

- 16. 4. 12

10

4

DEBURR

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 76283

76283

Page 2

Tuesday, November 08, 2011 1:31:36 PM

Item ID: D3908-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Stud Receiver, Lower
 Start Date: 11/8/2011 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 11/22/2011 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00				10	0		
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				10	0		
160 *160* Packaging Packaging	Identify as per dwg & Stock Location. Memo	0.00 0.00							

(10x) Sp 11-11-18.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 76283***76283***

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Tuesday, November 08, 2011 1:31:36 PM

Item ID: D3908-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Stud Receiver, Lower

Start Date: 11/8/2011 Start Qty: 10.00

10

Cust Item ID:

Required Date: 11/22/2011 Req'd Qty: 10.00

10

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Stop

NR2

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

11/11/21
⑩

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, November 08, 2011 1:31:42 PM

Page 1

Work Order ID: 76283

76283

Parent Item: D3908-3

D3908-3

Parent Item Name: Stud Receiver, Lower

Start Date: 11/8/2011

Required Date: 11/22/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A NEW ISSUE 09-11-24 JLM VERIFIED BY:DD IPP Rev:B
as per dwg revB DD 10.04.20 verified by:EC IPP Rev:C per ECN10-
581 10.05.28 DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M303B1.000X2.000		Purchased	No			100	f	12.1929	0.333333	3.508768			
------------------	--	-----------	----	--	--	-----	---	---------	----------	----------	--	--	--

M303B1 000X2 000

303 BAR 1" X 2"

Location

Loc Qty

Loc Code

MAT050

12.1929

114899

12.1929

3.509 F.K. 11/11/13.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	74283
Description: Stud Receiver Lower		Part Number:	D3908-3
Inspection Dwg: D3908 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.25	+0.005/-0.001	.252	✓		3C106	
0.625	+/-0.010	.630	✓			
0.368	+/-0.010	.370	✓			
Ø0.453	+0.010/-0.000	.461	✓			
1.95	+/-0.030	1.942	✓			
Ø0.38	+/-0.030	.377	✓			
0.63	+/-0.030	.630	✓			
2.43	+/-0.030	2.43	✓			
0.63	+/-0.030	.63	✓			
0.75	+/-0.030	.750	✓			
0.38	+/-0.030	.380	✓			
R0.06	+/-0.030	.060	✓			
R0.25	+/-0.030	.250	✓			
3.80	+/-0.030	3.801	✓			
0.735	+0.000/-0.010	.735	✓			
Ø0.129	+0.005/-0.001	.130	✓			
1.25	+/-0.030	1.25	✓			
15°	+/-0.5°	15°	✓		Protractor	
1.587	+/-0.010	1.588	✓		3C106	
1.588	+/-0.010	1.587	✓			
0.31	+/-0.030	.310	✓			
0.750	+/-0.010	.752	✓			
0.95	+/-0.030	.950	✓			
0.99	+/-0.030	.990	✓			
90°	+/-0.5°	90°	✓		Protractor	
0.06 x 45°	+/-0.030 x 0.5°	.060	✓		3C106	
0.80	+/-0.030	.800	✓		"	

Measured by: <i>SC / SA</i>	Audited by: <i>A.A</i>	Preliminary Approval:
Date: 11/11/14	Date: 11/11/16	Date:

Rev	Date	Change	Revised by	Approved
A	10.04.01	New Issue	KJ	
B	10.04.20	Dwg Rev updated	KJ	
C	10.08.25	Dwg Rev updated	KJ	

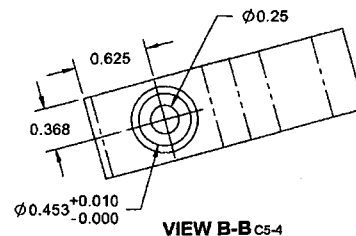
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

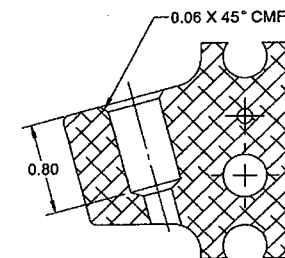
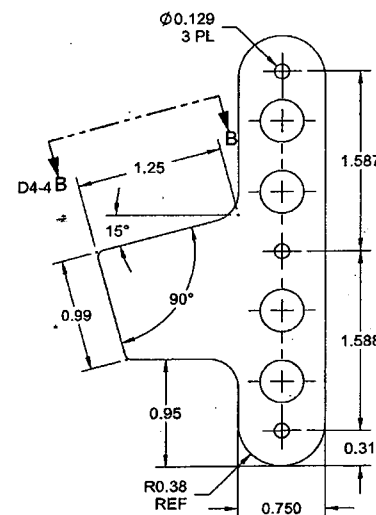
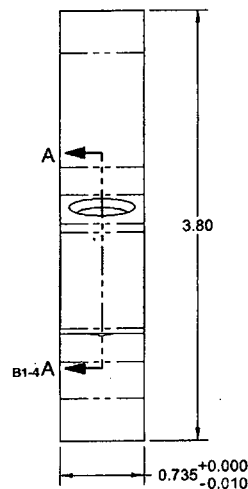
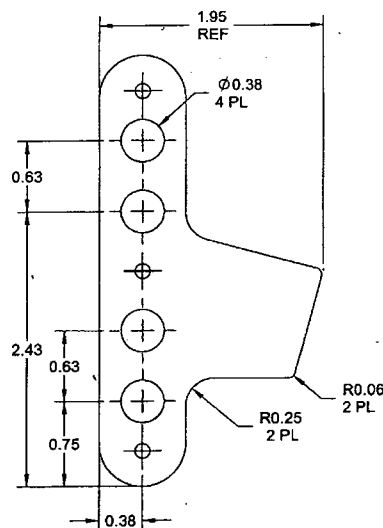
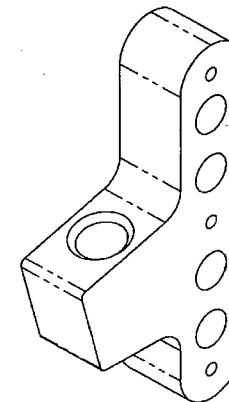
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO CHANGE
WITHOUT NOTICE
WORK ORDER NO. 76283
11-11-08



SECTION A-A B6-4

D3908-3 STUD RECEIVER LOWER

RELEASED
2010-05-28

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276
PER DART SPEC M303B OR M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.69 lbs

DESIGN	JFH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO. D3908	REV. C
CHECKED			SHEET 4 OF 5
MFG. APPR.		TITLE X-TUBE LUG ASSY (AFT)	SCALE NTS
APPROVED		COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DE APPR.			
DATE	10.05.27		

W/O:		WORK ORDER CHANGES					
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